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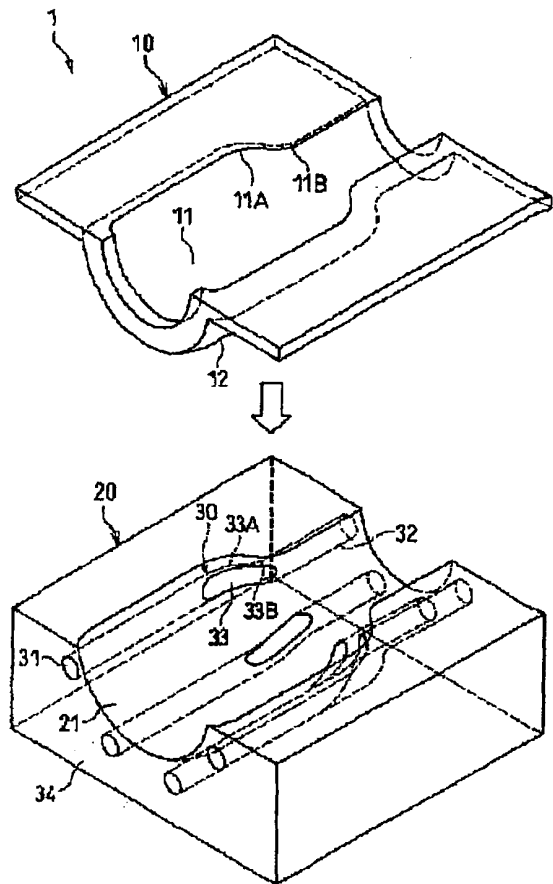
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TITLE : METAL MOLD



ABSTRACT : PROBLEM TO BE SOLVED: To uniformize the cooling of a molding part and improve the productivity of a mold by a method wherein cooling water passages along the curved surface part having a plurality of different curvatures of the molding part are provided.

SOLUTION: On the insert fitting surface 21 side of a base 20, a plurality of cooling water passages respectively running along the height direction of a bottle are provided in the molding part 11 of an insert 10. Each cooling passage consists of straight water passages 31 and 32 and a curved surface-like water passage 33, which is worked by ball-milling from the sides of a molding rear surface part 12 and of the insert fitting surface 21. In this case, the curved surface-like water passage 33 is worked so as to give a curved surface-like water passage 33A along the curved surface part 11A of the molding part 11 at the connecting part with the straight water passage 31 and give a curved surface-like water passage 33B along the curved surface part 11B of the molding part 11 at the connecting part with the straight water passage 32. Further, some part of the straight water passage 31 and the curved surface-like water passage 33 is completed by fitting the insert 10 into the base 20. Thus, the uniformization of cooling of the molding part 11 provided in the molding 1 becomes possible and the productivity of the mold can be improved.

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